

I CLAIM:

1. A one-part liquid concentrated color developer replenisher composition, which comprises a 4(N-ethyl-N-2-hydroxyethyl)-2-methylphenylenediamine-containing developer, and a sufficient amount of a hydroxylamine antioxidant to extend the shelf-life of said composition comprising at least N,N-bis(2-sulfoethyl)hydroxylamine or a salt thereof, said composition further characterized by satisfactory developer performance.

2. The one-part liquid concentrate color developer replenisher composition of claim 1 wherein the hydroxylamine antioxidant is a disodium salt of N,N-bis(2-sulfoethyl)hydroxylamine.

3. The one-part liquid concentrate color developer replenisher composition of claim 1 wherein the hydroxylamine antioxidant comprises at least a salt of the N,N-bis(2-sulfoethyl)hydroxylamine in combination with at least one other hydroxylamine antioxidant.

4. The one-part liquid concentrate color developer replenisher composition of claim 3, wherein the one other hydroxylamine antioxidant is diethylhydroxylamine or a salt thereof.

5. A one-part liquid concentrated color developer replenisher composition, which comprises a 4(N-ethyl-N-2-hydroxyethyl)-2-methylphenylenediamine-containing developer, a shelf-life extending amount of a hydroxylamine antioxidant comprising at least N,N-bis(2-sulfoethyl) hydroxylamine or a salt thereof; a buffer for maintaining the pH of the composition in a range from about 10 to about 12, and a photographically acceptable solvent system, said composition further characterized by satisfactory developer performance.

6. The one-part liquid concentrated color developer replenisher composition of Claim 5 which is a monophasic concentrate.

7. The one-part liquid concentrated color developer replenisher composition of Claim 5 which is a multiphase concentrate.

8. The one-part liquid concentrated color developer replenisher composition of Claim 6 wherein the monophasic concentrate comprises a polyhydric alcohol.

9. The one-part liquid concentrated color developer replenisher composition of Claim 7 wherein the multiphase concentrate comprises an upper caprolactam-containing phase comprising the 4(N-ethyl-N-2-hydroxyethyl)-2-methylphenylenediamine-containing developer and the N,N-bis(2-sulfoethyl) hydroxylamine antioxidant or salt thereof, and a lower aqueous phase comprises the buffer.

10. The one-part liquid concentrated color developer replenisher composition of Claim 9 wherein the caprolactam-containing multiphase concentrate comprises a third phase in the form of a solid precipitate comprising a salt.

11. The one-part liquid concentrated color developer replenisher composition of Claim 5 which is a diphasic concentrate comprising a polyhydric alcohol-containing liquid phase and a solid phase comprising a salt.

12. A method for preparing a stabilized one-part liquid concentrated color developer replenisher composition, which comprises the steps of:

(i) dissolving a 4(N-ethyl-N-2-hydroxyethyl)-2-methylphenylenediamine-containing developer in an alkaline solution comprising a base, and an antioxidant comprising at least N,N-bis(2-sulfoethyl)hydroxylamine or a salt thereof;

(ii) introducing a photographically compatible organic solvent, and

(iii) introducing a buffering agent to maintain the pH of the solution in a range from about 10 to about 12, said

composition further characterized by satisfactory developer performance.

5 13. The method of Claim 12 wherein the photographically compatible organic solvent is a polyhydric alcohol, and the one-part liquid concentrated developer replenisher composition is a monophasic concentrate, said method including the step of removing a salt precipitate.

10 14. The method of Claim 12 wherein the photographically compatible organic solvent is a polyhydric alcohol, and the developer concentrate is a diphasic system comprising a liquid phase and a solid phase comprising a salt.

15 15. The method of Claim 12 wherein the photographically compatible organic solvent is a caprolactam which forms a diphasic system comprising an upper caprolactam-containing solvent and a lower aqueous phase, said method including the step of removing a salt.